

Work Order ID 74291

Tuesday, September 27, 2011 1:59:29 PM

Page 1

Item ID: D4278-045

Accept

Revision ID:

Item Name: Rib Assembly, Fwd Cham

Start Date: 9/27/2011 Start Qty: 2.00

Required Date: 9/30/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: *MF*Date: *11-09-27*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4277

D

D4278

C

100

Weld per dwg A/R S.S. rod Batch: *117884* 0.00

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs and weld as per dwg

P/11-09-27 *(4)*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.09.27 *(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74291

Tuesday, September 27, 2011 1:59:29 PM



Page 2

Item ID: D4278-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, Fwd Cham

Start Date: 9/27/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 ulca/29



130

Identify as per dwg & Stock Location: WA

0.00



Packaging

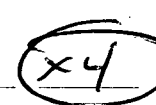
Memo

0.00

Packaging

STOCK IN BASKET CELL

0.00 09.29



140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/34

ME 11-09-29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 1:59:25 PM

Page 1

Work Order ID: 74291

Parent Item: D4278-045

Parent Item Name: Rib Assembly, Fwd Cham

Start Date: 9/27/2011

Required Date: 9/30/2011


Start Qty: 2.00


Required Qty: 2.00



Comments: IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC



IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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* D4277-11		Manufactured	No			100	Each	0.0000	1	2			
													
Rib													

* D4277-7		Manufactured	No			100	Each	0.0000	1	2			
													
Rib													

 B74279 →  9/27/11 09:29

 B74281 →  9/27/11 09:29

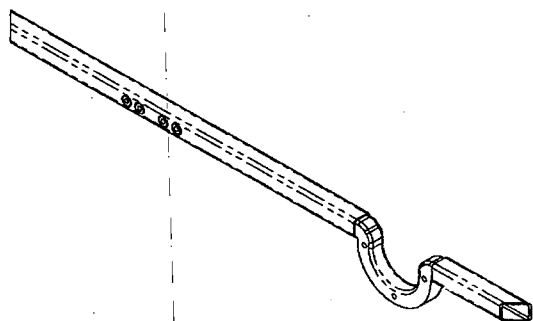
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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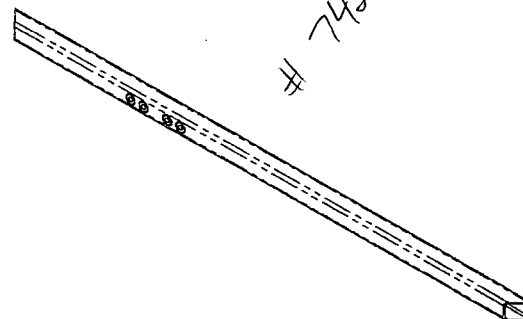
NOTE: Date & initial all entries



D4278-041 UPPER RIB ASSY-HOOP



D4278-045 RIB ASSY, FWD CHAM



D4278-047 UPPER RIB ASSY-STRAIGHT



RELEASED
2011-01-18
AM

REV.	DESCRIPTION	BY	DATE
C	ADDITIONAL HOLES ADDED IN D4278-041-047	SC	10.12.23
B	RMV -043 (OBSOLETE)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D4278	SHEET 1 OF 4
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	RIB ASSEMBLY	NTS
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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

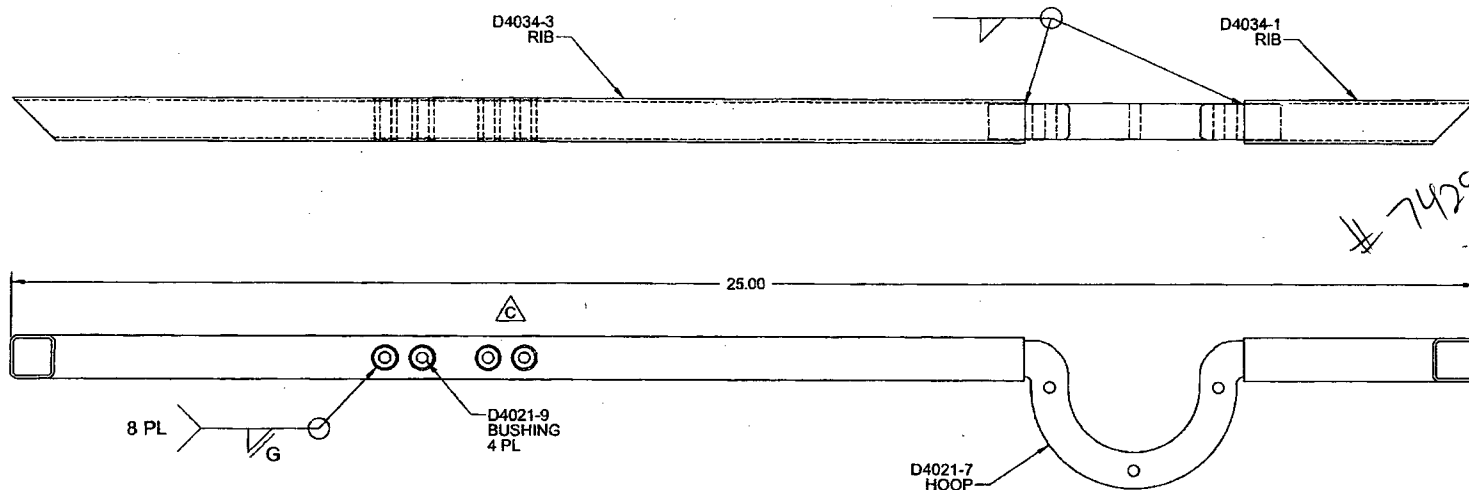
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NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
		D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	4	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB



D4278-041 UPPER RIB ASSY-HOOP

RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	JRH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 2 OF 4
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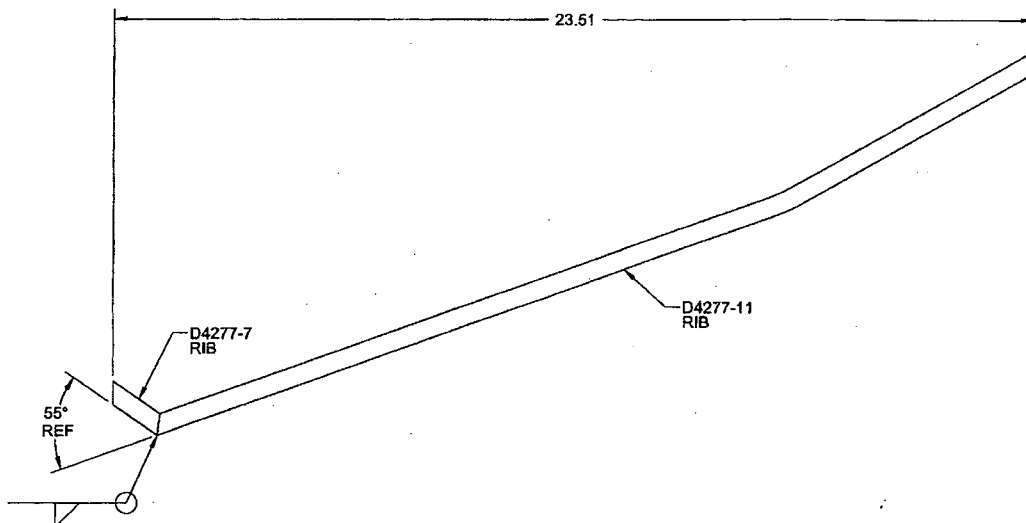
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

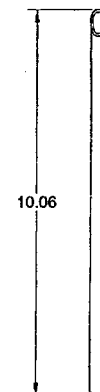
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB





D4278-045 RIB ASSY, FWD CHAM



74291

RELEASED
2011-01-18

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.57 lbs
 - 8) WELD PER DART QSI 004.

DESIGN	JRH	DART AEROSPACE LTD	
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CHECKED	SC	DRAWING NO.	REV. C
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W/O:		WORK ORDER CHANGES					
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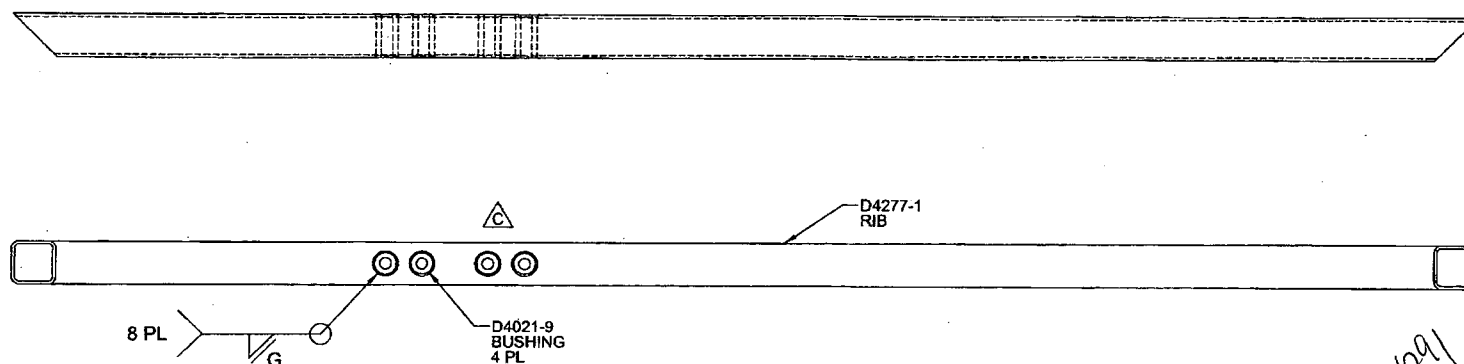
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NOTE: Date & initial all entries

ITEM	QTY -047	PART NUMBER	DESCRIPTION
		D4278-047	UPPER RIB ASSY-STRAIGHT
1	4	D4021-9	BUSHING
2	1	D4277-1	RIB



D4278-047 UPPER RIB ASSY-STRAIGHT

74291

RELEASED
2011-01-18

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.95 lbs
 - 8) WELD PER DART QSI 004.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 4 OF 4
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